

Date: Thursday, 12/04/2007 6:54:37 AM  
 User: Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SADDLE FITTING, FWD (OUTBOARD/INBOARD)		
Job Number	: 31806		Part Number	: D2571		
Estimate Number	: 10530		Drawing Number	: D2571 REV E		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 12/04/2007	S.O. No. : N/A	Drawing Revision	: E		
Prsh Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 19/04/2007 Qty: 10 Um: Each		
Previous Run	: 31719					
Written By	:					
Checked & Approved By	:					
Comment	: Est: 102.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572KJ					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6101007	7075-T7351 8.25X7.75X2.5	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s) 7075-T7351 8.25X7.75X2.5 Make from D6101-007 billet for D2571 Ensure that grain is along 7.75" length Batch No: <u>3253555</u> 07/04/21 X10	
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Program Batch No. <u>B31806</u> Double check by: <u>JF</u>  1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets 4-Deburr and remove all machining marks 5-Tumble to remove sharp edges.	
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
		Comment: CONVENTIONAL MILLING MACHINE Machine keyway as per dwg D2571 & D2572	

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 01/05/02  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 31806

Part Number: D2571

Job Number:



Seq. #:	Machine Or Operation:	Description :
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		Er / SD / 07/04/27
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
5.0	QC8	SECOND CHECK
		J.F. 07/04/27 (10)
	Comment: SECOND CHECK	
6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
		10X 07/04/30
	Comment: HAND FINISHING RESOURCE #1	
	Acid etch and Alodine as per QSI 005 4.1	
7.0	POWDER COATING	POWDER COATING
		M-103706 07-05-01 (10)
	Comment: POWDER COATING	
	Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3	
8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
		P 07/05/02 (10)
	Comment: INSPECT POWDER COAT	
9.0	PACKAGING 1	PACKAGING RESOURCE #1
		07/05/02 (10)
	Comment: PACKAGING RESOURCE #1	
	Identify and Stock	
	Location: _____	
10.0	QC21	FINAL INSPECTION/W/O RELEASE
		07/05/02 (10)
	Comment: FINAL INSPECTION/W/O RELEASE	

Job Completion



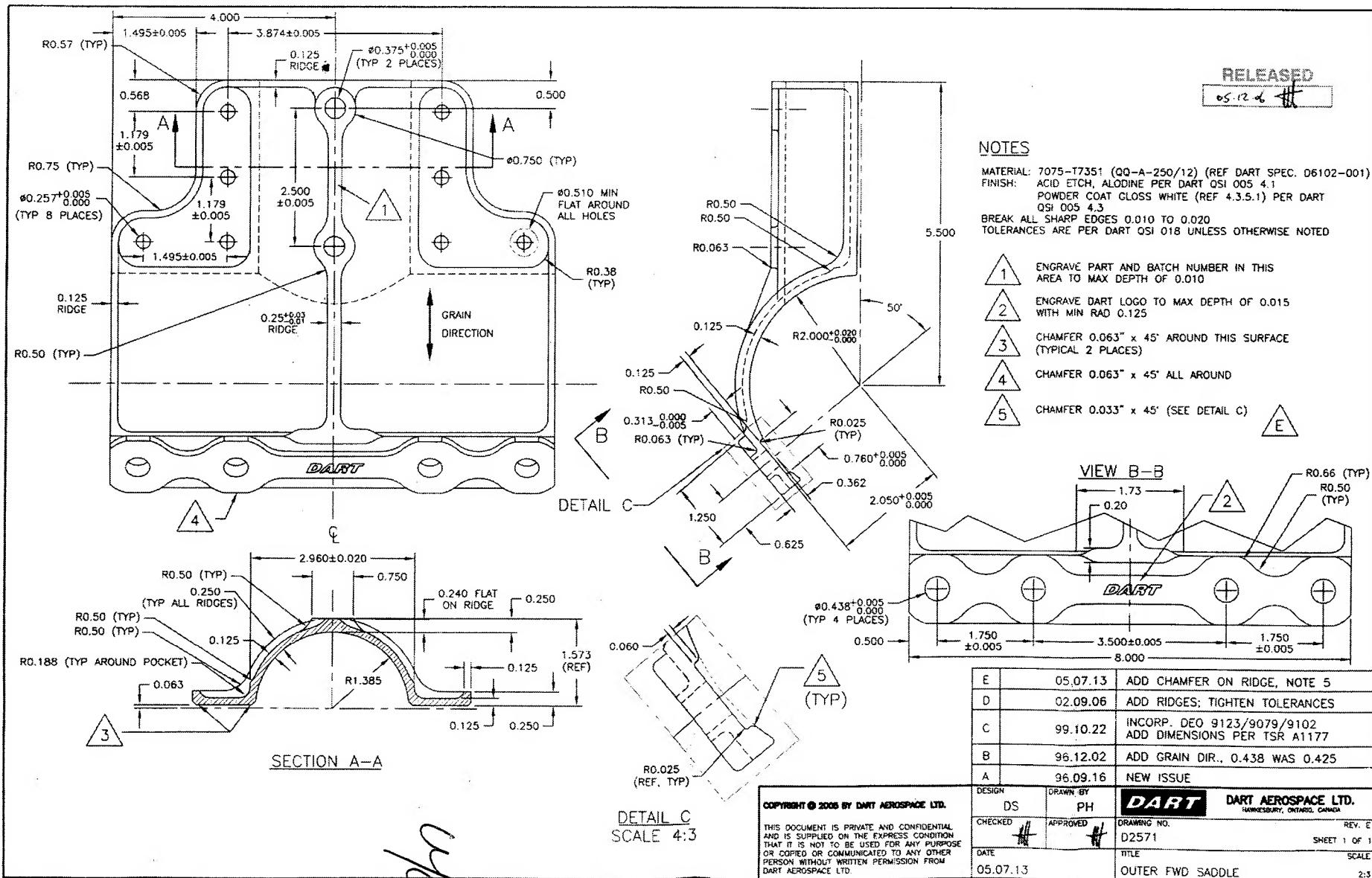
G 07/05/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



05.12.13 #

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD

Work Order:

3(80)

Description: Saddle, Fwd Outboard

Part Number:

D2571

Inspection Dwg: D2571 Rev. E

Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		0.440	0.440	0.440	0.440		
B	1.745	1.755		1.749	1.747	1.740	1.747		
C	3.495	3.505		3.500	3.500	3.500	3.501		
D	1.745	1.755		1.749	1.747	1.748	1.748		
E	7.990	8.010		8.001	8.001	8.001	8.001		
F	0.490	0.510		0.499	0.498	0.498	0.494		
G	0.257	0.262		0.260	0.260	0.260	0.260		
H	0.375	0.380		0.377	0.377	0.377	0.377		
I	0.490	0.510		0.501	0.502	0.501	0.501		
J	1.174	1.184		1.174	1.172	1.177	1.177		
K	0.558	0.578		0.564	0.565	0.565	0.565		
L	1.174	1.184		1.174	1.172	1.175	1.176		
M	1.490	1.500		1.495	1.492	1.494	1.492		
N	2.495	2.505		2.496	2.496	2.495	2.498		
O	3.869	3.879		3.870	3.870	3.871	3.871		
P	0.115	0.135		0.117	0.117	0.127	0.126		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.251	0.252	0.250	0.254		
S	0.115	0.135		0.127	0.131	0.131	0.127		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.961		
V	0.230	0.250		0.231	0.237	0.231	0.233		
W	0.115	0.135		0.121	0.121	0.121	0.121		
X	0.308	0.313		0.311	0.311	0.311	0.312		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.360	0.365	0.364	0.363		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.625	0.625	0.625	0.627		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.251	0.251	0.251	0.252		
AE	1.375	1.395		1.386	1.386	1.385	1.385		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.252	0.252	0.252	0.251		
AI	2.000	2.020		2.001	2.001	2.000	2.000		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by: EP SA  
Date: 07/04/24Audited by: J.F.  
Date: 07/04/27

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD

Work Order:

31806

Description: Saddle, Fwd Outboard

Part Number:

D2571

Inspection Dwg: D2571 Rev. E

Page 1 of 1

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A	0.438	0.443		.440	.440	0.440	0.440		
B	1.745	1.755		1.748	1.748	1.749	1.748		
C	3.495	3.505		3.499	3.499	3.499	3.498		
D	1.745	1.755		1.749	1.748	1.749	1.748		
E	7.990	8.010		8.002	8.001	8.002	8.004		
F	0.490	0.510		.494	.494	0.497	0.494		
G	0.257	0.262		.258	.258	0.260	0.260		
H	0.375	0.380		.376	.376	0.377	0.377		
I	0.490	0.510		.496	.496	0.500	0.501		
J	1.174	1.184		1.176	1.177	1.178	1.175		
K	0.558	0.578		.564	.564	0.567	0.563		
L	1.174	1.184		1.176	1.176	1.178	1.175		
M	1.490	1.500		1.494	1.495	1.495	1.494		
N	2.495	2.505		2.499	2.500	2.500	2.498		
O	3.869	3.879		3.871	3.871	3.872	3.871		
P	0.115	0.135		.124	.125	0.127	0.126		
Q	0.115	0.135		.135	.135	0.131	0.135		
R	0.240	0.260		.252	.253	0.252	0.252		
S	0.115	0.135		.125	.125	0.131	0.130		
T	0.178	0.198		.188	.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		.238	.238	0.236	0.237		
W	0.115	0.135		.132	.132	0.121	0.126		
X	0.308	0.313		.310	.310	0.311	0.311		
Y	0.760	0.765		.762	.762	0.765	0.765		
Z	0.352	0.372		.365	.365	0.362	0.365		
AA	0.470	0.530		.500	.500	0.500	0.500		
AB	0.615	0.635		.627	.627	0.627	0.628		
AC	0.053	0.073		.063	.063	0.063	0.063		
AD	0.240	0.260		.247	.248	0.249	0.250		
AE	1.375	1.395		1.386	1.385	1.386	1.386		
AF	0.115	0.135		.135	.135	0.135	0.135		
AG	0.240	0.280		.258	.258	0.260	0.260		
AH	0.240	0.260		.246	.246	0.250	0.248		
AI	2.000	2.020		2.000	2.00	2.001	2.001		
AJ	0.023	0.043		.032	.032	0.033	0.033		
Accept/Reject									

Measured by: En / M8

Date: 07/04/25

Audited by: J.F.

Date: 07/04/27

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD				Work Order:	31806
Description: Saddle, Fwd Outboard				Part Number:	D2571
Inspection Dwg: D2571 Rev. E				Page 1 of 1	

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D	1.745	1.755		1.748	1.750				
E	7.990	8.010		8.002	8.004				
F	0.490	0.510		0.497	0.493				
G	0.257	0.262		0.260	0.260				
H	0.375	0.380		0.377	0.377	7	c		
I	0.490	0.510		0.503	0.500				
J	1.174	1.184		1.178	1.178				
K	0.558	0.578		0.566	0.563				
L	1.174	1.184		1.178	1.178				
M	1.490	1.500		1.492	1.496				
N	2.495	2.505		2.499	2.497				
O	3.869	3.879		3.872	3.870				
P	0.115	0.135		0.127	0.126				
Q	0.115	0.135		0.135	0.135				
R	0.240	0.260		0.253	0.252				
S	0.115	0.135		0.130	0.131				
T	0.178	0.198		0.188	0.188				
U	2.940	2.980		2.960	2.960				
V	0.230	0.250		0.236	0.238				
W	0.115	0.135		0.120	0.124				
X	0.308	0.313		0.311	0.311				
Y	0.760	0.765		0.765	0.765				
Z	0.352	0.372		0.367	0.362				
AA	0.470	0.530		0.500	0.500				
AB	0.615	0.635		0.626	0.627				
AC	0.053	0.073		0.063	0.063				
AD	0.240	0.260		0.249	0.253				
AE	1.375	1.395		1.385	1.385				
AF	0.115	0.135		0.135	0.135				
AG	0.240	0.280		0.260	0.260		0..		
AH	0.240	0.260		0.253	0.252				
AI	2.000	2.020		2.001	2.000				
AJ	0.023	0.043		0.033	0.033				
Accept/Reject									

Measured by:	SP	Audited by:	J.F.
Date:	07/04/27	Date:	07/04/27

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
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D	05.05.05	Added dimension AI	KJ/RF	
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